

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025876**Date Inspected:** 23-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China

CWI Name:	Sha Zi	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	OBG	

Summary of Items Observed:

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 9

This QA Inspector observed the following work in progress for Bay 9.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Chen Xi Gang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Traveler Rail

PCMK: TR3018TR2-001-037

Welder: 059421

WPS-B-T-2132-ESAB

PCMK: TR3017TR1-001-011

Welder: 059443

WPS-B-T-2231-ESAB

PCMK: TR3017TR2-037

Welder: 059416

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WPS-B-T-2132-ESAB

Components: Bike Path

PCMK: BKSA13-001-009,010

Welder: 059378

WPS-B-T-2233-ESAB

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was performing match drilling on splice plate angles and shim plates for lifts 13 and 14. ZPMC was also noted performing grinding to smooth the edges of areas that had been cut by Oxygen/Acetylene cutting and removing the burr's caused by drilling.

Bay 16

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Ma Chun Li.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Traveler Rail

PCMK: TR3004TR1-001-004

Welder: 222396

WPS-B-T-2232-ESAB

PCMK: TR3004TR1-001-004

Welder: 201074

WPS-B-T-2232-ESAB

Heat straightening of PCMK, BKR-G-005, under approved Heat Straightening procedure, HSR 1 (B)-10418, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Ma Chun Li. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 8mm.

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Ma Chun Li.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Bike Path

PCMK: BK9003-001-001~008

Welder: 062794

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

WPS-B-T-2132-ESAB

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
